

Wednesday, July 08, 2015 8:58:26 AM

134241

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Weld Pin

Stop *NS2*

Start Date: 7/8/2015 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 7/8/2015 **Req'd Qty:** 20.00

20

Customer:

Reference:

Approvals: Process Plan: MCS Date: Jul 08 2015

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

SPC (Y/N):

Date:

Stop *NR2*

100		0.00		
100	Hardinge CNC LATHE SMALL			
Hardinge	Memo	0.00	20	φ JFC 2015-07-08
Hardinge CNC Lathe Small	1- Turn D5190-3 as per Folio FB _____ & Dwg D5190 Folio Rev: <u>AA</u> Dwg Rev: <u>A</u> 2-Deburr			
110	QC2- Inspect parts off machine FAI/FAIB	0.00		
110				
QC	Memo	0.00	20	φ JFC 2015-07-08
Quality Control				
120	QC8- Inspect parts - second check	0.00		
120				
QC	Memo	0.00	20	Ø DAS 40 9-89
Quality Control				15/07/08

Work Order ID 134241

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134241

Page 2

Item ID: D5190-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Weld Pin

Stop ***NS2***

Start Date: 7/8/2015 Start Qty: 20.00

20

Cust Item ID:

Required Date: 7/8/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>WA001</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION: WA002								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

20 015-7-8ML5 JUL 10 2015ML5 JUL 10 2015

Picklist Print

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Page 1

Work Order ID: 134241

134241

Parent Item: D5190-3

D5190-3

Parent Item Name: Weld Pin

Start Date: 7/8/2015

Required Date: 7/8/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 14.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.375		Purchased	No				f	14.7705		2			
M4130NR0.375									**				
4130 steel RD bar .375"													

Location

Loc Qty

Loc Code

MAT032

14.7705

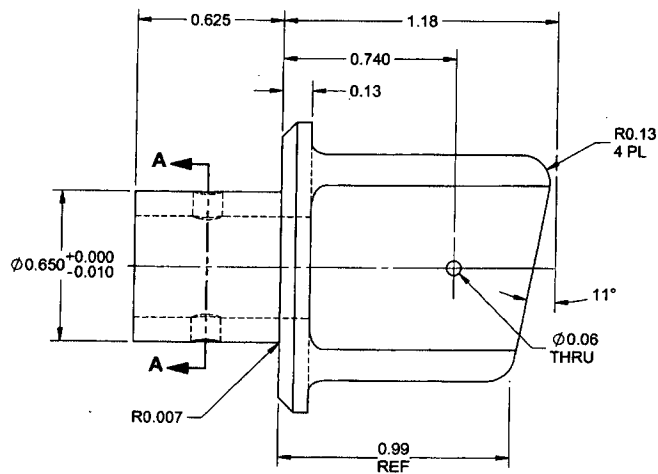
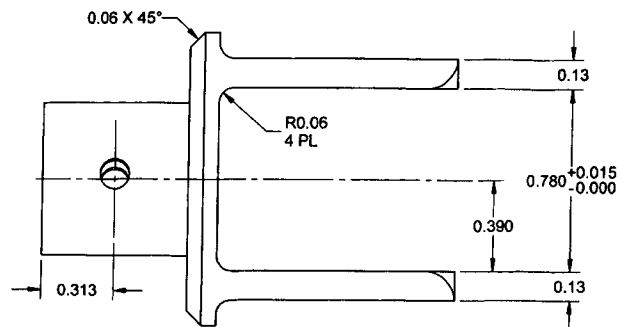
123724

3.7705

→ m132387

11

1.7 P1 JFC 2015-07-08

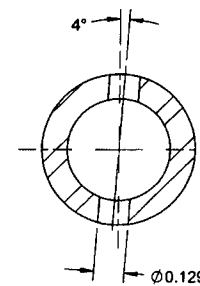
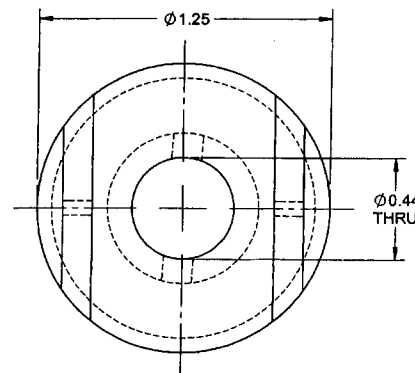
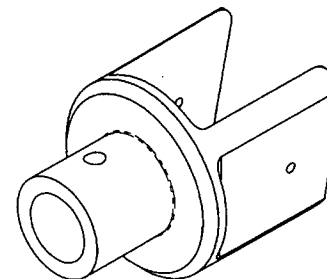


D5190-1 ARMREST FITTING

NOTES:

- 1) MATERIAL: AISI 4130N ROUND BAR
PER MIL-S-6758 OR AMS 6348/6370/6528
REF M4130N-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 134241 MWS
15-07-08



SECTION A-A

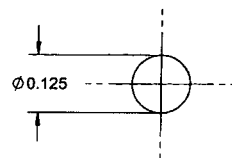
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2015 FEB 04

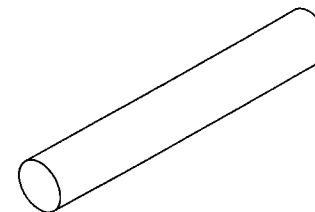
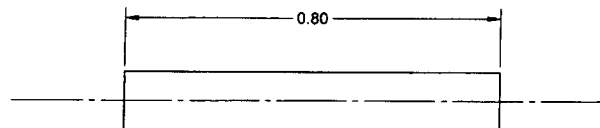
REN 15-522 GP

APPROVED

A		NEW ISSUE		AJS	14.11.19	
REV.		DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	AJS					
CHECKED	AP	DRAWING NO.	REV. A			
MFG. APPR.	JLM	D5190	SHEET 1 OF 2			
APPROVED	HS	TITLE	SCALE			
DE APPR.	DS	ARMREST MACHINED PARTS	NTS			
DATE	14.11.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD				



D5190-3 WELD PIN



NOTES:

- 1) MATERIAL: AISI 4130N ROUND BAR
PER MIL-S-6758 OR AMS 6348/6370/6528
REF M4130N-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: <0.01 lbs

RELEASED

2015 FEB 04

ECN 15-522 9P

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5190	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARMREST MACHINED PARTS	
DATE	14.11.19	NTS	

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